NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Dat	:e:
						DISPOSITION				AGAINST DE	PARTIMENT	/PROCESS	ing growing a financial of case, a september of
Work Orde Part N NCR N	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	iption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Descr	iption	Date	Verification	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FAUI	LT CATE	GORY				
Landi	ng G	iear				General	<u>i</u>						
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped. at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled d	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss,	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	1 1	Torquo M	lavor in E	vtrucio	<u>. </u>	Drawing	14	I Out of (^alihration				

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio

	Vork Order ID 99340 pril-05-13 1:18:00 PM			*99340*									
Revision ID:	D3065-5 Step Leg			Accept	*N900	040	100)* s	etup Sta	1 70	S1* S2*	-A =	
	4/09/13 4/19/13	Start Qty: 50.00 Req'd Qty: 50.00	*50° *50°		Cust Item l Customer:	D:							
Approvals:	Process P QC:	lan:	Date:			ate:		R	un Sta Sto	" [V]	R1* R2*		
Sequence ID/ Work Center II	D '	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co Memo	at per QSI005 4.1	0.00				58	DA	713-4	15		
140 *140* QC		QC3- Inspect Part Finish Memo		0.00				<u>584</u>			[] []3]] 04][
Quality Control		Identify as per dwg & Sto	ock Location: 6 - 1	0.00				782		/		2/2	
150 Packaging Packaging		Memo		0.00				3 0.1				>/°9/	

NCR: Y	'es / No				WORK ORDER NON-C	CON	FORM	MANCE / UP	DATE	QA Closed:	Date	:
Work Orde					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	The Control of the Co
Part N					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo			-	Work Order Update			Large Fab	Composite	Nec/3tol	Supplier	Other
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	_											
Operator												
Material												
Setup			1									
Other												
Process		ļ								}		
Supplier	_	1										
Training		1										
Unapproved	<u> </u>	<u> </u>	11			ΔIII T	CATE	GORY				
Landir	ng Gear				General	,						
	Bending			[Bend	\Box	Grain		[Ovalized	Γ	Pressure/Forced
	Centre No	ot Concer	ntric to C	o/s	BOM/Route		- Hardwa	ire		Over/Under	tolerance	Temperature/Cure
j	Cracks			·	Broken/Damaged		nspecti	ion Incomplete		Part Incorre		Weld
	Crushed/	Crimped.			Burrs		nstruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	•			Contamination		Mainte	enance		Part Moved	-	
	Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Wrong	
ļ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss,	'Surge	Other
Ī	Ripples in	Bend			Drill Holes		Offset					
	Torque W	Vaves in E	Extrusion		Drawing		Out of (Calibration				
	Turning S	equence			Finish		Out of 9	Sequence				

Outside Dimensions

DQA: _____ Date: ____

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*993	340*					,		Page 3
Item ID: Revision ID: Item Name:	D3065-5 Step Leg			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
	4/09/13	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item I Customer:	D:						.7/
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp
*160 *160*		QC21- Final Inspection -	Work Order Release	0.00						13/4	1/16	,

Quality Control

MBary,

NCR:	⁄es	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er: .					DISPOSITION	٦		Skid-tube	AGAINST D	EPARTMENT,	/PROCESS Water Jet	Engineering
Part f				·		Rework Scrap Use-as-is Work Order Update		II.	Machining noforming Large Fab	Small Fab Finishing Composite		d. Eng. Coor. re/Packaging Supplier	Quality Other
									·		_		
Root Cause		Date	Step	Qty	· '	otion of work order update or Non-conformance	1	Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data						·		1					
Equip/Tooling Operator]					
Material Setup													
Other													
Process													
Supplier Training													
Unapproved			L	<u> </u>			<u>L</u> i		6001			<u> </u>	<u> </u>
1						General	AU	LT CATE	GORY				
Landi	_	Bending				Bend		Grain		ŗ	Ovalized		Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	+	Hardwa	ıre	-	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	IT	Inspect	ion Incomplete	<u> </u>	Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe		L.	Positioned V		7
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d t		Power Loss/	Surge	Other
		Ripples in	Bend		L	Drill Holes		Offset					
		Torque W	/aves in E	xtrusio	n [Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

DQA: Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

Picklist Print

April-05-13 1:18:00 PM

Work Order ID:

99340

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 4/09/13

Required Date: 4/19/13

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:F Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	254.5600	0.825	43.421055 48			Jn13-4.
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT021		254.560032				<u> </u>			
				1172	285	0.497264				-			
				1247	786	254.062768			197	1386			

NCR: Y	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE	QA Closed:	Date	:
Work Orde	r:				DISPOSITION				AGAINST DE		7. · · · · · · · · · · · · · · · · · · ·	
		,, *		<u>·</u>	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap		l f	Machining	Small Fab		d. Eng. Coor.	Quality
					Use-as-is	4	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	0	-			Work Order Update	J		Large Fab	Composite	İ	Supplier	
Root				Descri	ption of work order update		hitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	_											
Operator												
Material		İ										
Setup												
Other		:								1		
Process											:	
Supplier						1						
Training										•		,
Unapproved									······································	<u></u>		
-					F	AUI	T CATE	GORY				
Landin	g Gear				General		-		_	,	_	
	Bending				Bend	\perp	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
[Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Γ	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong _	_
Ī	Inspection	n Strip in	Tube		Cut Too Short		Misrea	d ·		Power Loss/	Surge	Other
Ī	Ripples in	Bend			Drill Holes		Offset			_		
	Torque W	/aves in E	Extrusio	n	Drawing		Out of	Calibration				
	Turning S				Finish		Out of	Sequence				
F	Wave/Tw				Folio		Outside	Dimensions				•

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99340
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	6.458	~		T	JAMO6
15.750	+/-0.005	15.350"	-		T	
2.250	+/-0.005	2.249"	_		ν	Jumos
3.460	+/-0.005	3.457"	_		٧	
0.865	+/-0.005	0.864^)		ν	
6.020	+/-0.005	6.020"	_	!	ν	
1.205	+/-0.005	1.206			V	·
3.484	+/-0.005	3.487"	<u> </u>		V	
0.871	+/-0.005	0.870"	_		V	
8.325	+/-0.010	8.330"	-		V	Produser
0.551	+/-0.010	0.549"	_		V	
0.213	+0.005/-0.000	0,215"	-		v	
Ø0.128	+0.005/-0.000	0.129			ν	
			,			
				·····		

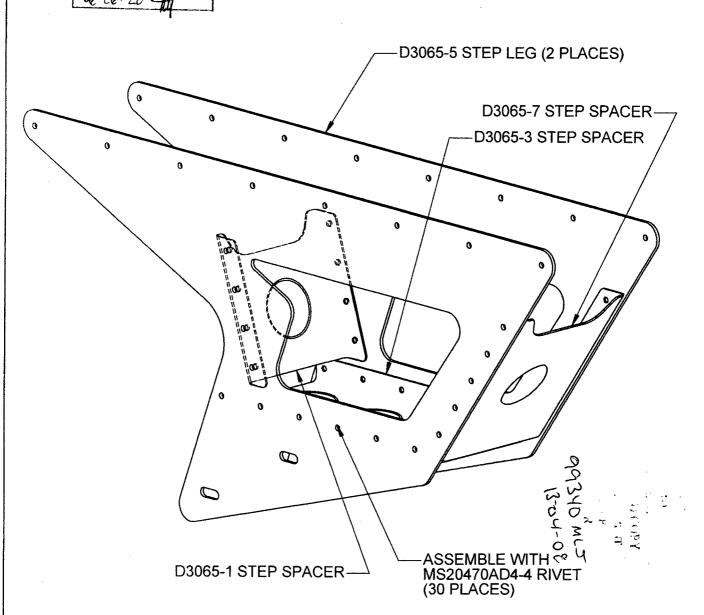
M	easured by: TM	Audited by:	27	Prototype Approval:	N/A
	Date: 13-4-11	Date:	13472	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 1.A	21
С	06.06.23	Dwg Rev. changed	KJ/JLM 🛠	411



	DESIGN	4 CB		DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
	CHECK	ED	APPROVED	DRAWING NO.	REV. B
ļ		111		D3065	SHEET 1 OF 5
	DATE	06.0)E 02	TITLE	SCALE
		06.0	05.23	STEP LEG ASSEMBLY	1:2
	Α	0:	2.09.11	NEW ISSUE	
	В	06	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS	TO D3065-5

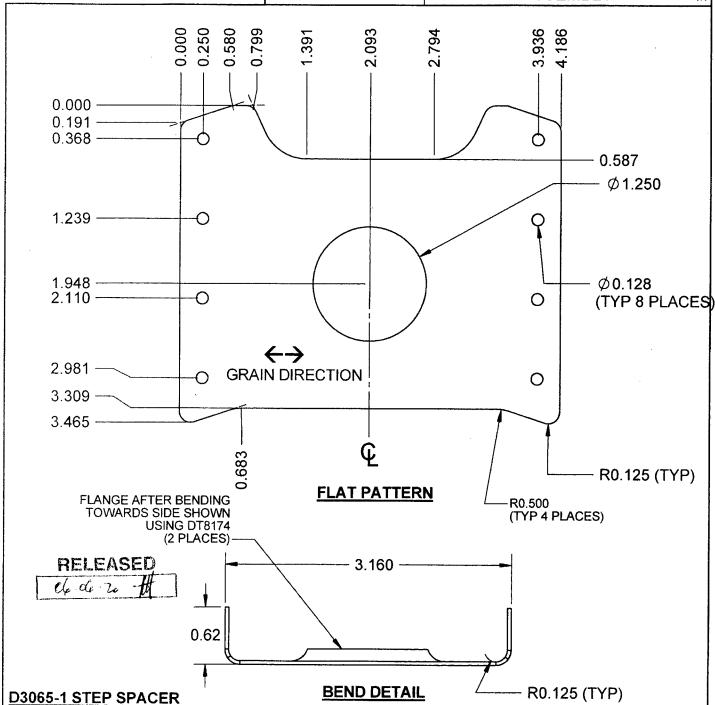
RELEASED 6 c6 20



D3065-041 STEP LEG ASSEMBLY







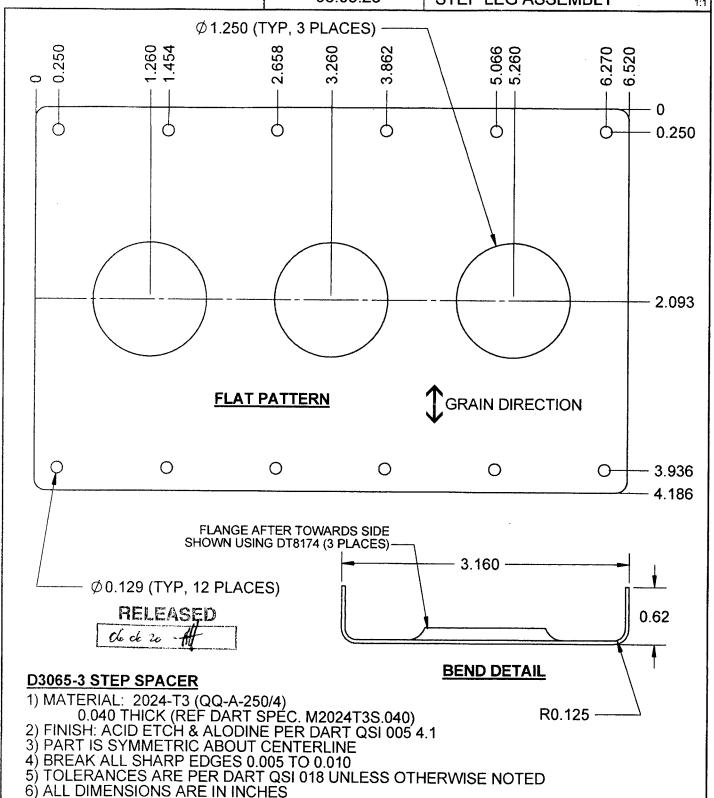
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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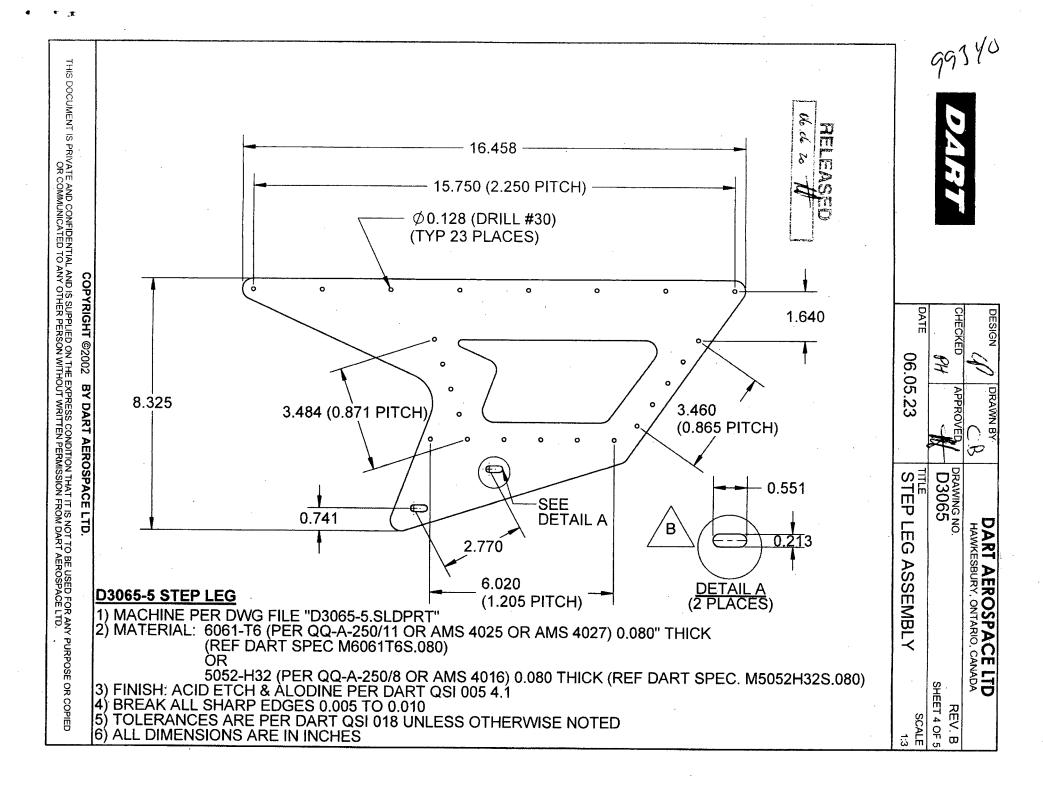






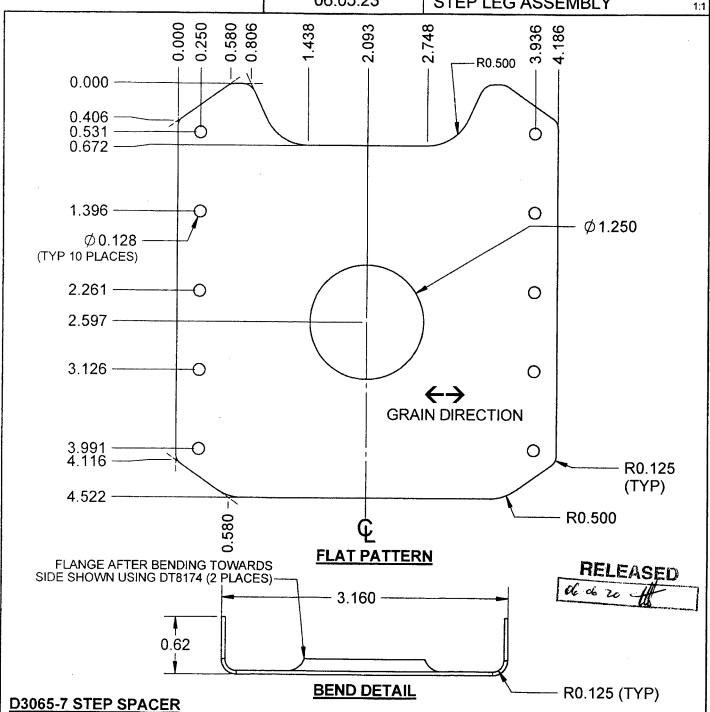
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- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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